



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2938-2BL
Job Sheet 167808



Part No: D2938-2BL

Job Qty: 10 ea

Part Name: Saddle RH Out, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/7/17

Job Tracking No:

Due Date: 11/24/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Rev C

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/22/17	11/22/17	0.00	0.00	Start Up Machining		FK 17-12-2
100	CNC Vertical Machining	10 pcs	11/23/17	11/23/17	0.35	15.24	HAAS 1		FK 17-12-4
110	Mill Conv	10 pcs	11/23/17	11/23/17	0.00	15.24	Mill Conv 1		FK 17-12-4
120	QC	10 pcs	11/23/17	11/23/17	0.00	0.00	QC1		FK 17-12-4
130	QC	10 pcs	11/23/17	11/23/17	0.00	0.00	QC8		FK 17-12-4
140	HandFinish	10 pcs	11/23/17	11/23/17	0.00	0.84	HandFinish1		2617-12-12 JSC
150	SprayPaint	10 pcs	11/24/17	11/24/17	0.00	1.50	Spray Paint		DAS
160	QC	10 pcs	11/24/17	11/24/17	0.00	0.00	QC14		PD/ 11 JAN 17 2018
170	Packaging	10 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3	ST 3.9%	DEC 9-89 18/01/17
180	QC21-SA	10 Ea	11/24/17	11/24/17	0.00	0.00	QC21		DEC 14 2017

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - ***MASK ALL HOLES AS PER PAR16-484***

REV C

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-003	10	18	0	0
	5016578				

Part Specifications

Specifications could not be found.

Plex 11/7/17 8:23 AM dart.Michaud-Febrille.Victoria

DQA:

Date:

QA Closed:

Date:

Work Order:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only



DISPOSITION

AGAINST DEPARTMENT/PROCESS

Rework

Material

Date:

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7

CANADA

TEL.: 1 613 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Inter
Trib

S016579



Saddle RH Out, 206

PART NO: D2938 - 2BL

Revision:

Operation: Start up Operation

Change No:

Mfg Date: 12/02/17

Job No: 167808

Drill Holes

S016579



Saddle RH Out, 206

PART NO: D2938 - 2BL

Revision:

Operation: Outsource

Change No:

Mfg Date: 12/02/17

Job No: 167808

ter

☐	Positioned Wrong
☐	Outside Dimensions
☐	Over/Under tolerance
☐	Part Incorrect
☐	Part Lost/Missing
☐	Part Moved
☐	Drawing
☐	Finish
☐	Misread
☐	Turning Sequence

QC / QA Coordinator
ApprovalLead hand / Supervisor
Approval Verification

Completed By

MRB (QS1042) Approval

Engineering	☐
Quality	☐
Other	☐

Past Expiry Date
Misidentified

Past Due

OTHER:

DART AEROSPACE LTD	Work Order:	167808
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.116	.115	.115	.115		
B	0.100	0.140		.115	.113	.113	.114		
C	0.100	0.140		.115	.115	.115	.116		
D	0.210	0.230		.225	.226	.225	.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.121	.121	.121	.121		
O	0.540	0.560		.548	.549	.548	.548		
P	0.490	0.510		.500	.500	.500	.501		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.744	2.745	2.745	2.745		
S	0.240	0.270		.255	.255	.255	.255		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585		1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				/	/	/	/		

Measured by:	FK
Date:	17-12-4

Audited by:	A.F
Date:	17-12-04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	167808
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	8		
A	0.100	0.140		.115	.115	.114	.114		
B	0.100	0.140		.115	.114	.113	.114		
C	0.100	0.140		.116	.116	.116	.116		
D	0.210	0.230		.225	.224	.224	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.313	.313	.313	.313		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.120	.120	.120	.120		
O	0.540	0.560		.547	.548	.548	.548		
P	0.490	0.510		.501	.500	.500	.500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.745	2.745	2.745	2.745		
S	0.240	0.270		.255	.255	.255	.256		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.316	.316	.316	.316		
X	1.250	1.270		1.260	1.260	1.260	1.260		
Y	1.565	1.585		1.575	1.575	1.575	1.575		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				/	/	/	/		

Measured by:	FR
Date:	17-12-4

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	167808
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	9	10	3	4		
A	0.100	0.140		.114	.115				
B	0.100	0.140		.114	.114				
C	0.100	0.140		.116	.116				
D	0.210	0.230		.225	.224				
E	1.245	1.255		1.250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.500				
H	0.510	0.515		.511	.511				
I	1.572	1.582		1.577	1.577				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.313	.313				
M	0.235	0.240		.238	.238				
N	0.100	0.140		.121	.121				
O	0.540	0.560		.547	.548				
P	0.490	0.510		.500	.501				
Q	3.715	3.725		3.720	3.720				
R	2.720	2.760		2.745	2.745				
S	0.240	0.270		.255	.255				
T	0.100	0.180		.135	.135				
U	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.367	1.367				
W	0.316	0.321		.316	.316				
X	1.250	1.270		1.260	1.260				
Y	1.565	1.585		1.575	1.575				
Z	0.178	0.198		.188	.188				
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject				✓	✓				

Measured by:	FR
Date:	17-12-4

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038646

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO038646
PO Date: 12/14/17
Due Date: 12/15/17
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	167807	D2938-1BL	Saddle LH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
2	167808	D2938-2BL	Saddle RH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
3	167804	D2932-2BL	Saddle RH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** SPRAY PAINT BLEU	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
4	167806	D2933-2BL	Saddle RH In, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
5	167811	D2939-2BL	Saddle RH In, 206 ** MASK ALL HOLES AS PER PAR16-484***	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
6	167803	D2932-1BL	Saddle LH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** BATCH: _____	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
7	167805	D2933-1BL	Saddle LH In, 206 *** MASK ALL HOLES AS PER PAR16-484*** BATCH: _____ ISSUE PO _____	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
8	167810	D2939-1BL	Saddle LH In, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
9	168325-A	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00



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PURCHASE ORDER

PO038646

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____							
10	167820-L	D206-642-341BL	Replacement Skidtube (Fits LH or RH) ISSUE PO _____ ***MASK ALL SADDLE AND GROUND HANDLING ATTACHMENT HOLES AS PER PAR16-484*** Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
11	167820-K	D206-642-341BL	Replacement Skidtube (Fits LH or RH) ISSUE PO _____ ***MASK ALL SADDLE AND GROUND HANDLING ATTACHMENT HOLES AS PER PAR16-484*** Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Grand Total:										\$1,675.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/17/18 10:04 AM dart.baker.diane